



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200
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D3537-1

Job Sheet 192968



Part No: D3537-1

Job Qty: 60 pcs

Part Name: Wearpad



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/5/19

Job Tracking No:

Due Date: 4/26/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D3537 REV.F IPP Rev:A New Issue 07-02-14 JLM IPP REV:B 15.10.16 added automated welding DD
verf:JLM IPP REV:C 18.11.09 AS PER DWG REV.F DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
105	Waterjet - Flow - 1	60 pcs	4/26/19	4/26/19	0.00	2.58	Waterjet - Flow			219/05/14
125	QC 8	60 pcs	4/26/19	0.00	0.00	QC 8 - 12				
						QC 8 - 14				
						QC 8 - 17				
						QC 8 - 20				
						QC 8 - 25				
						QC 8 - 3				
						QC 8 - 32				
						QC 8 - 33				
						QC 8 - 35				
						QC 8 - 39				
						QC 8 - 4				
						QC 8 - 44				
						QC 8 - 45				
						QC 8 - 49				
						QC 8 - 58				
						QC 8 - 8				
						QC 8 - 9				
						QC 8 - 68				
						QC 8 - 67				
						QC 8 - 1 (A)				
						QC 8 - 47				
						QC 8 - 40				
						QC 8 - 52				
QC 8 - 23										
0.78	Small Fab - Brake - 1 - B4B								DAS 30 989 MAY 2 1 2019	
	Small Fab - Brake - 2 - B4B									
	Small Fab - Brake - 3 -									



Container No: S181203



Part: D3537 - 1
Job No: 192968
Serial No/Batch: S181203
Revision: F
Inspector:
Exp Date:
Instructions: Various STC's

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Date: 05/23/19



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				B4B	
150 QC 5	60 pcs	4/26/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	EL
				QC 5 - 30	
				QC 5 - 40	
160 Automated Welding - B4B	60 pcs	4/26/19	0.00 4.45	Automated Welding - 1 - B4B	HU ME
170 QC 10	60 pcs	4/26/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	EL
				QC 10 - 58	
				QC 10 - 9	
180 QC 5	60 pcs	4/26/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	EL
				QC 5 - 30	
				QC 5 - 40	
210 Packaging 3-1 - Stock - B4B	60 pcs	4/26/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	EL
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	

				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
220	QC 21 - SA	60 pcs	4/26/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

DAS

21

9-58

MAY 23 2019

Part Op **105** - 1-Cut D3537-1 as per Dwg D3537 Dwg Rev: F Prog Rev: F 2-Debur if necessary

Descriptions: **125** - (QC8- Inspect parts - second check)

140 - (Form as per dwg)

150 - (QC5- Inspect part completeness to step on W/O)

160 - (Automated welding) ***SEE NOTE 8 FOR SURFACE BUILDUP*** 1- WELD AS PER DWG AND QSI004 4.5 FOR AUTOMATED WELDING USE 8259 HARDCOAT BATCH: _____

170 - (QC10- Inspect visual per QSI004- ground welds)

180 - (QC5- Inspect part completeness to step on W/O)

210 - (Identify as per dwg & Stock Location: EP001)

220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	6.3600 sf (.106 ea)	105-Waterjet - Flow - 1	8159674

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
105-Waterjet - Flow - 1	M304S16GA	6	271	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearpad	4.250inches $\pm$ 0.010	4.260 4.240		
2	Wearpad	3.500inches $\pm$ 0.010	3.510 3.490		
3	Wearpad	1.970inches $\pm$ 0.030	2.000 1.940		
4	Wearpad	3.630inches $\pm$ 0.030	3.660 3.600		
5	Wearpad	2.420inches $\pm$ 0.010	2.430 2.410		
6	Wearpad	0.220inches $\pm$ 0.010	0.230 0.210		
7	Wearpad	0.375inches $\pm$ 0.010	0.385 0.365		
8	Wearpad	0.063inches $\pm$ 0.010	0.073 0.053		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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